Work Ord Monday, Januar			a 4 5	*111	1746*						Page 1
Item ID: Revision ID: Item Name:	D3451-045  Handle And Lo	n 3	345 1 - 045 B 11 17 46	Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup S		S1* S2*
Start Date: Required Date: Reference:		Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:				, ,	
Approvals:	Process Plan	n:	Date: 14-1-20	Tooling: SPC (Y/N):		ate:		R		top	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3451	Rev A	A									
100				0.00							
*100* Large Fab Large Fab		Large Fab  Memo  Weld as pe	r dwg PB67-43001	0.00				_5	14-0	10	lD
		·	. ung 1207 13001								
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00							
*110* QC Quality Control		Мето		0.00				_5_	12	14-2-	//
				DAS							
<sup>120</sup> <b>*1 2∩*</b>		QC5- Inspect part comp	pleteness to step on W/O	0.00 27				<			
QC		Memo		0.00	2/1 <b>1</b>						

Quality Control

DQA: Date:													
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
, , , , , , , , , , , , , , , , , , ,						Rework			Skid-tube Crosstube	Γ	]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	$\overline{}$	Pro	d. Eng. Coor.	Quality
	-				_	Use-as-is			noforming Finishing		1	e/Packaging	Other
NCR N	١ο٠ ـ					Suspected Unapproved			Large Fab Composite			Supplier	
D 4	_				Daga		Н	midial	Action		Cian 9		
Root		Data	Ston	O+1/	Desci	ription of work order update or non-conformance		nitial iief Eng			Sign & Date	Verification	QC Inspector
Cause	$\vdash$	Date	Step	Qty		or non-comormance	Cii	ilei ciig	Description		Date	Vermeation	QC IIISPECTOI
Design Doc/Data	$\dashv$		1										
Equip/Tooling	$\dashv$			•									
Handling/Pre	Н												
Material													
Operator		•									. '		
Offset/Setup	П												
Process							l				· .		
Supplier							ļ					:	
Training													
Transport													
Unapproved													
							FAI	ULT CA	TEGORY				
Landi	_	I			_	General		1 /-		_	1		7 <sub>5</sub> /5
	Ш	Bending			-	Bend	<u> </u>	4	Program	-	Outside Dim	<del></del>	Pressure/Forced
		Centre No	ot Concer	ntric	$\vdash$	BOM/Route	-	Grain		$\vdash$	Over/Under	<del></del>	Set-up Temperature/Cure
	-	Crimp/Viv	ak/Dinnla	MAInus	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa	are ion Incomplete/Unqualified	$\vdash$	Part Incorre	<del> </del>	Weld
	Crimp/Kink/Ripple/Wave			Burrs Contamination	$\vdash$	┪ ˙	tions Incomplete/Unclear	$\vdash$	Part Moved	_	Wrong Stock Pulled		
	$\vdash$	Crushing			-	Countersink	$\vdash$	-1	gned/off center	H	Positioned V		T TOO B STOCK T UNCC
	Crushing Heat Treat		-	Cut Too Short	-	Mislab			Power Loss/		Other		
	Inspection Strip in Tube		Drawing	$\vdash$	Misrea		L	١٠٠٠، ١٠٥٥/					
	Marks/Chatter		Drill Holes	$\vdash$	Off-set								
			Finish		-	Calibration							
	Turning Sequence Wave/Twist in Tube			Fit/Function	L	4	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord Monday, Janua				*111	746*							Page 2
Item ID: Revision ID: Item Name:	D3451-045 Handle And I	Lock-Down Assembly		Accept	*N900	040	100	)*	Setup	Start Stop	171.	_
Start Date: Required Date Reference:	1/20/2014 : 1/31/2014	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item 1 Customer:	D:						.,
Approvals:	Process Pla	an:	Date:	Tooling:		ate:	_		Run	Start	*NF	<b>२</b> 1*
Approvals:				SPC (Y/N):		ate:				Stop	*NF	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*130 *130* HandFinish Hand Finishing		Chemical Conversion Co	oat per QSI005 4.1	0.00				5		H )	4-2-11	
<sup>140</sup> <b>*1∆∩*</b>	·	Green Sandtex(Ref:4.3.5	5.8) per QSI005 4.3	0.00				5	ct	<b>5</b> /:	p/-,Э-)	·

Powdercoat

Powder Coating

150

QC3- Inspect Part Finish

0.00

\*150\*

Memo

Quality Control

5 SAM 14/02/14

0.00

DQA:	QA: Date:													•	
						WORK ORDER NON	-CC	ONFO	RMANCE / U			<b>.</b> .		_	AEROSPACE
QA Closed:	,		Date:							<u> </u>	Nork	Order up	date only		
Work Orde	sr.					DISPOSITION				AGAINST E	DEPAF	RTMENT	/PROCESS		
Work Orac	-				—	Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	_	Pro	d. Eng. Coor.	一	Quality
	•				<del></del>	Use-as-is	1		noforming	Finishing			re/Packaging		Other
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite		•	Supplier		
	•						_								
Root					Desc	ription of work order update	I	Initial	Act	tion	3	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	$\perp$	Date	Verification	1	QC Inspector
Design			ļ				1								
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup							1								•
Process	Щ														
Supplier															
Training															
Transport	Н														
Unapproved				1	l			III T CA	TEGORY				1		
l andi					···	General	FA	OLI CA	IEGON1						
Landi		Bending				Bend	Г	Teolio/I	Program	Γ	$\neg_{\circ}$	tside Dim	ensions		Pressure/Forced
	$\vdash$	Centre No	ot Concei	ntric		BOM/Route	$\vdash$	Grain	108.4		_		tolerance	_	Set-up
	$\vdash$	Cracks	or conten	10110	<u> </u>	Broken/Damage/Defect		Hardwa	are	ļ.		rt Incorre	1	_	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		-∤	tion Incomplete/U	ngualified	Pa	rt Lost/M	issing	$\overline{}$	Weld
	⊢	Cuffs		,		Contamination		<b>⊣</b> `	tions Incomplete/	· · ·	<del></del>	rt Moved		Π,	Wrong Stock Pulled
		Crushing				Countersink	T	<b>-</b> 4	gned/off center	ļ		sitioned \	Vrong .		
ļ	Г	Heat Trea				Cut Too Short		Mislab	=	Ţ	Po	wer Loss/	Surge		Other
		Inspectio		Tube		Drawing		Misrea	d	•			· · · · · ·		
		Marks/Cl				Drill Holes		Off-set	:						
		Turning S	equence			Finish		Out of	Calibration						
	Turning Sequence Wave/Twist in Tube			Teit/Function	1	Out of	Sequence								

 $<sup>\</sup>Box$  H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde Monday, Januar				*11	1746*							Page 3
Item ID: Revision ID: Item Name:	D3451-045	ock-Down Assembly	A	Accept	*N900	<u>040</u>	100	)* :	Setup	Start Stop	*N	S1* S2*
Start Date: Required Date: Reference:	1/20/2014	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item 1 Customer:	D:					*N	<b>ふン</b> ^
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 160 *1 60* Small Fab Small Fab	•	Operation Description  Small Fab  Memo 1- assemble	rubber handle as per dwg PB	Set Up/ Run Hours 0.00 0.00 667-43001	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	. N	Reject Number	Insp. Stamp  FF  14-02-14
170 *170* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00 DAS 27 0.00 9-35 U				S				
180 <b>*1 A \*</b> Packaging		Identify as per dwg & St	ock Location: <u>ME2</u> Z	0.00				5				DAS 14-02-14

9-89

Packaging

DQA:			Date:											TRAGE
			<b>.</b> .			WORK ORDER NON-	-CC	ONFO	RMANCE / U			l Oude -		AEROSPACE
QA Closed:			Date:								wor	k Order up	date only	
Work Orde	er:					DISPOSITION	- 1			AGAINST (	DEP	ARTMENT/	PROCESS	
	-					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	$\neg$	Prod	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing			e/Packaging	Other
NCR 1	١o.					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desci	ription of work order update		nitial		tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	$\perp$	Date	Verification	QC Inspector
Design	Щ				i				ļ					
Doc/Data	$\Box$						ļ		:					
Equip/Tooling	Щ					:							!	
Handling/Pre														
Material														
Operator	,A								ļ					
Offset/Setup							١				İ			
Process														
Supplier	Ш										1			
Training			ļ											
Transport								`						
Unapproved			ļ											
							FAI	ULT CA	TEGORY					
Landi		•				General		1	_	Г	<b>—</b> .			7
		Bending			<u> </u>	Bend	<u> </u>	4	Program	-	_	Outside Dim	·	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		-	_	Over/Under	<u> </u>	Set-up
		Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa			_	Part Incorred	<del> </del>	Temperature/Cure
	Crimp/Kink/Ripple/Wave			-	Burrs	$\vdash$	<b>i</b> '	ion Incomplete/U	· ·	-	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination	<b> </b>	4	tions Incomplete/			Part Moved	L	Wrong Stock Pulled	
į	Crushing			<u> </u>	Countersink	$\vdash$	- 1	gned/off center	}	_	Positioned V		Other	
·	Heat Treat			-	Cut Too Short	-	Mislab		l.	'لـــا	Power Loss/	ourge	Joulei	
]	Inspection Strip in Tube			<u> </u>	Drawing	-	Misrea			_			. <del></del> .	
	Marks/Chatter		-	Drill Holes	$\vdash$	Off-set	•		-					
	Turning Sequence			-	Finish	$\vdash$	4	Calibration		_				
[	Wave/Twist in Tube				Fit/Function		Jout of	Sequence				<u> </u>		

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde				*111	1746*				F	Page 4
Item ID: Revision ID: Item Name:	D3451-045	Lock-Down Assembly		Accept	*N90004	<b>೧1</b> 00*	Setup	Start Stop	*NS1	
Start Date: Required Date: Reference:	1/20/2014	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:			•	*NS2	,^
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1	=
Sequence ID/ Work Center II	D	Operation Description OC21- Final Inspection	Work Order Delegge	Set Up/ Run Hours	Tool ID Too	l# Plan Ac Code Qt		£.	Reject Insp Number Star	•

0.00

Memo

\*1 90\*

Quality Control

# 14-02-18 ALUOZ.14

DQA:			Date:											DART
						WORK ORDER NON	-CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:			Date:								W	ork Order up	date only	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS	
WOIK OIG						Rework	1		Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	Quality
:	•		•		_	Use-as-is	1		noforming	Finishing		1	e/Packaging	Other
NCR N	10.					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desc	ription of work order update		nitial	Ac	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design														
Doc/Data							١							
Equip/Tooling														
Handling/Pre														2"
Material							[							
Operator					ļ				[	•				
Offset/Setup														
Process							İ					<b>,</b>		
Supplier			ł											
Training							1.							
Transport	Ш						ļ		ļ					
Unapproved			<u> </u>	<u> </u>			<u></u>							
							FA	ULT CA	TEGORY				<u> </u>	
Landi	_	1				General		1				Outside Dim	ansians [	Pressure/Forced
	<b>-</b>	Bending			-	Bend BOM/Route	-	-	Program			-4	<b>-</b>	Set-up
<u> </u> 		Centre No	ot Concei	ntric	-	BOM/Route	-	Grain			-	Over/Under Part Incorre	<u> </u>	Temperature/Cure
		Cracks	. /n: 1		$\vdash$	Broken/Damage/Defect	-	Hardwa		la acceliticad	<u> </u>	Part Income	<del>-</del>	Weld
	⊢	Crimp/Kii	пк/кірріе	e/wave	-	Burrs	$\vdash$	<b>⊣</b> `	tion Incomplete/U		-	Part Moved	221118	Wrong Stock Pulled
	├	Cuffs				Contamination	-	-1	tions Incomplete/		$\vdash$	Positioned V	L Vrong	
	$\vdash$	Crushing			<u> </u>	Countersink	$\vdash$	4	gned/off center		-	Positioned v		Other
	Heat Treat Inspection Strip in Tube		$\vdash$	Cut Too Short	$\vdash$	Mislab Misrea			<u></u>	Trower ross/	Juige [	Jones		
	$\vdash$	1 '	-	rube	-	Drawing	$\vdash$	Off-set						
	$\vdash$	Marks/Cl			-	Drill Holes Finish	$\vdash$	<b>-</b> i	Calibration					
	Turning Sequence Wave/Twist in Tube		-	Fit/Function	$\vdash$	-1	Sequence			<del></del>				
1	1	į vvave/ i w	vist in Tul	ue	1	JEIG FUNCTION	- 1	Tour or	Sequence					

Monday, January 20, 2014 3:58:39 PM

Work Order ID:

111746

Parent Item:

D3451-045

Parent Item Name: Handle And Lock-Down Assembly

**Start Date:** 1/20/2014

Required Date: 1/31/2014

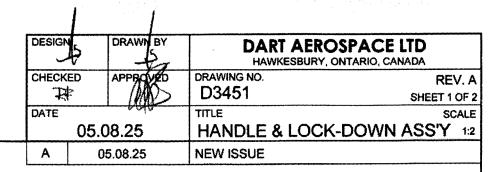
Start Qty: 5.00

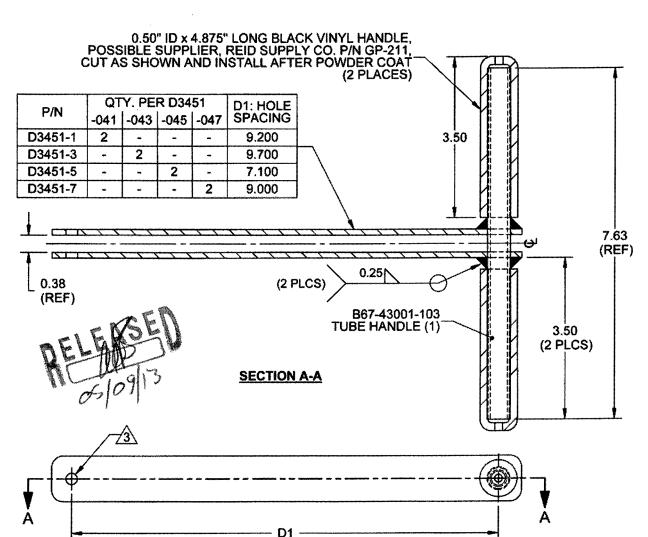
Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3451-5		Manufactured	No			100	Each	11.0000	2	10	~~		~
Tube Handle Arm											(D)	14-0	2-10 B
				Location		Loc Oty	La	oc Code					
				Mezz2		9			III	17-7 12			
				922	270	1							
				935	537	8							
				ST372		2							
				104	1818	2							-·
GP-211 Rubber Handle		Purchased	No			100	Each	115.0000	2	10	F	F 14	<u>-02-14</u>
Rubber Handle													
				<b>Location</b>		Loc Qty	<u>L</u>	oc Code					
				ST283		15				<del></del>			
				123	3937	15							
				ST284		100							
				<u>M1</u>	<u>27975</u>	100				10			
<b>PB67-43001-103</b> Tube Handle		Manufactured	No			100	Each	20.0000	1	5	(5)	GO-DI	-10 PD
				<b>Location</b>		Loc Qty	<u>La</u>	oc Code					<u> </u>
				Mezz		4			כווד	76-51			
				525	570	4				· · · · · · · · · · · · · · · · · · ·			
				Mezz2		16							
				100	0015	12							
				908	391	4							

DQA:			Date:											
						<b>WORK ORDER NON-</b>	·CC	NFOF	RMANCE / UF	PDATE				AEROSPACE
QA Closed:			Date:							1	Woı	rk Order up	date only	
						DISPOSITION				AGAINST I	DEP	ARTMENT	PROCESS	
Work Ord	er: _	· · · · · · · · · · · · · · · · · · ·			·	,	l		a 🗀	г	$\neg$			¬
D a set						Rework	Į		Skid-tube	Crosstube	$\dashv$	Dua	Water Jet	Engineering
Part	۱O. <sub>-</sub>					Scrap	ı		Machining noforming	Small Fab Finishing	$\dashv$		d. Eng. Coor. e/Packaging	Quality Other
NCR	No.					Use-as-is Suspected Unapproved			Large Fab	Composite	$\dashv$	Nec/3tor	Supplier	
IVER	٠٠.					Juspected Onapproved			Laige Tab	composite			20ppilei [	
Root					Desc	ription of work order update		nitial	Acti	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance		ief Eng	Descri	iption		Date	Verification	QC Inspector
Design											$\sqcap$		-	
Doc/Data		:												
Equip/Tooling											1			
Handling/Pre														
Material														
Operator	$\Box$													
Offset/Setup														
Process														
Supplier							ļ							
Training	Ц													
Transport	Ш													
Unapproved														
							FAL	JLT CAT	TEGORY					\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
Land		1				General		l ,.		Г	$\overline{}$		. г	
	Ш	Bending			-	Bend			Program		-	Outside Dim	-	Pressure/Forced
	_	Centre No	ot Concer	ntric	-	BOM/Route	-	Grain		}	-	Over/Under	<del>-</del>	Set-up
	$\vdash$	Cracks	a la /ptana la	/\41	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa		a avalified	$\boldsymbol{\vdash}$	Part Incorred Part Lost/Mi	-	Temperature/Cure Weld
	Crimp/Kink/Ripple/Wave		-	Burrs	$\vdash$	1	ion Incomplete/Ur	t	-		Paring	Wrong Stock Pulled		
	$\vdash$	Cuffs			<u> </u>	Contamination Countersink		4	tions Incomplete/L gned/off center	Jucieal	_	Part Moved Positioned V		
	Crushing				Cut Too Short	-	Mislabe	=			Positioned v Power Loss/		Other	
	Heat Treat		-	Drawing	-	Misrea		l		I OWEL LUSS/	Juige [	19ther		
	Inspection Strip in Tube  Marks/Chatter		Drill Holes	$\vdash$	Off-set			-						
1	1	IMarke/Ch	latter	Turning Sequence										
		4			-	Finish	$\vdash$	4	Calibration		-			







# D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41 D3451-045 SUPERSEDES PREMIER P/N B67-43001-39 D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

#### NOTES:

- 1) WELD PER DART QSI 004 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 12 B. 12 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3 5) PART IS SYMETRICAL ABOUT CENTER LINE. 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 7) ALL DIMENSIONS ARE IN INCHES

- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

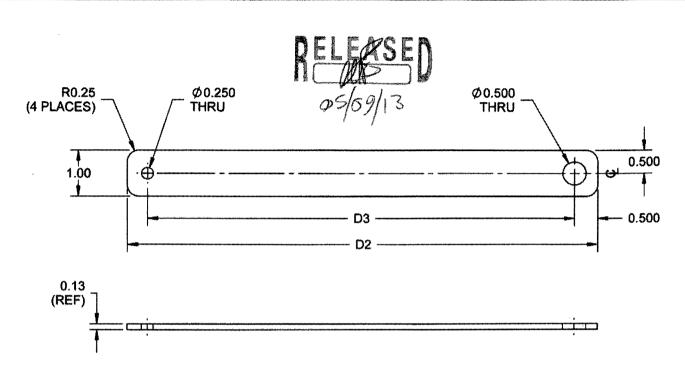


DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:			·				W	ork Order up	date only	
Work Orde	sr.					DISPOSITION			AGAINST	T DE	PARTMENT	PROCESS	
Work Orac	- ' ' -				_	Rework			Skid-tube Crosstube		]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fal	-	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR I	ю.					Suspected Unapproved		i	Large Fab Composite	-	]	Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	$\Box$												
Handling/Pre													
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Operator							ļ						
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Process					•								
Supplier			·										
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Transport	$\vdash$						1						
Unapproved		l	<u> </u>	<u>.                                    </u>	<u> </u>		FΔI	III T CA	TEGORY		J	<u> </u>	
Landi	ng (	Gear				General	17	OLI CA	120011		***************************************	· · · · · · · · · · · · · · · · · · ·	
Landi		Bending				Bend		] Folio/F	Program		Outside Dim	ensions [	Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route	$\vdash$	Grain	6	$\vdash$	Over/Under	<u> </u>	Set-up
	H	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa	are		Part Incorre	<b>-</b>	Temperature/Cure
	Г	ł	nk/Ripple	/Wave		Burrs	Г	4	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Crimp/Kink/Ripple/Wave Cuffs			Contamination		<b>-</b> 1 '	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
	Crushing			Countersink		Misali	gned/off center		Positioned V	Vrong	<del></del>		
	Heat Treat			Cut Too Short		Mislab			Power Loss/	Surge	Other		
Inspection Strip in Tube			Drawing		Misrea	d							
	Marks/Chatter			Drill Holes		Off-set							
Turning Sequence		Finish		Out of	Calibration								
	Wave/Twist in Tube				Fit/Function		Out of	Sequence					



1	1		
DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROXED	DRAWING NO.	REV. A
1	1 au	D3451	SHEET 2 OF 2
DATE		TITLE	SCALE
05	.08.25	HANDLE & LOCK	(-DOWN ASS'Y 12

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P/N	D2: CUT LENGHT	D3: HOLE SPACING			
D3451-1	10.25	9.200			
D3451-3	10.63	9.700			
D3451-5	8.00	7.100			
D3451-7	10.00	9.000			

## D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303 D3451-5 SUPERSEDES PREMIER P/N B67-43001-301 D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

#### NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
2) PART IS SYMETRICAL ABOUT CENTER LINE.
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

5) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE							DART
QA Closed: Date:						Work Order update only							
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No						Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fa Thermoforming Finishin		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								-					
							FA	ULT CA	TEGORY				
Landi		Bending Centre Not Concentric Cracks				General Bend BOM/Route Broken/Damage/Defect		Folio/Program Grain Hardware		Inqualified	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing		Pressure/Forced Set-up Temperature/Cure Weld
	Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube					Burrs Contamination Countersink Cut Too Short Drawing		Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread					Wrong Stock Pulled Other
	Marks/Chatter Turning Sequence Wave/Twist in Tube			_	Drill Holes Finish Fit/Function		-1	Off-set Out of Calibration Out of Sequence					